BELT FRAME - HULL STATION 0.33

BELT FRAME SYMMETRICAL ABOUT ℄ EXCEPT AS NOTED

VIEW SHOWN LOOKING FORWARD

SKIN LINE (INSIDE)

TEMPORARY TIE

.040 GUSSET

NOTE: DRILL HOLES BUT LEAVE OUT RIVETS WILL BE PUT IN AT FINAL ASSY WHEN 28F1422 IS INSTALLED

OMIT THESE RIVETS
DO NOT DRILL HOLES
RIVET TO BE REPLACED
AT INSTALLATION OF
28F1423 BOMBSIGHT
SUPPORT

.030 WEB FOR -550 ASSY.
.025 WEB FOR -0 ASSY

SEE DETAIL H FOR TYPICAL CONSTRUCTION

OMIT RIVETS IN THIS AREA UNTIL INSTALLATION OF 28B4266-6

SECTION LL

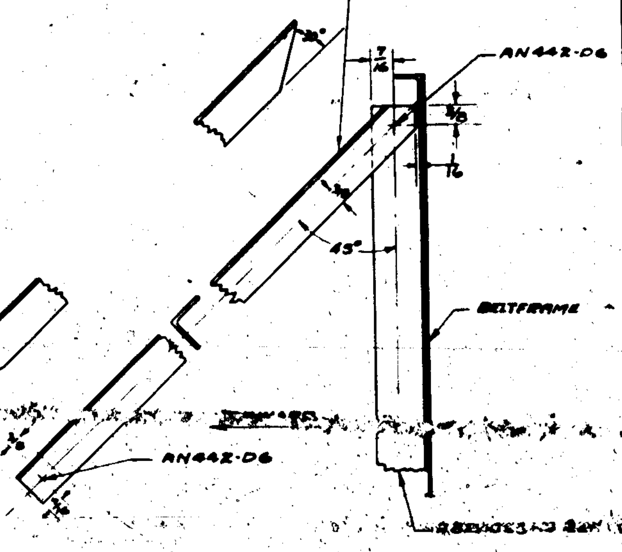
VIEW M-M

CHINE

KEELSON BEAM

LET	ALTERATION		
H	TRACED TO DATE		
J	INCORPORATED COMM. CHANGE ORDER "28BY"		
K	REVERSED DIRECTION OF STRING. ... WAS ... WAS ...	11-17-37	
L	CHGD DIRECTION OF STRINGE BACK ... WAS ... WAS ...	11-18-37	
M	REVERSED DIRECTION OF STRING. ADDED 1¾ DIM.		
N	ADDED NOTE "OMIT THESE RIVET, ETC."	12-21-37	
O	ADDED -23 & -550 ASSY. REMOVED -5	11-17-38	
P	ALUM. ALLOY SHEET WAS DRAWN ANGLE SECTION ...		
Q	-14 & -15 24 S O WAS 24 T		
R	ADDED NOTE "OMIT THESE RIVETS ETC."		
S	CHANGED BM REQ'TS FOR 28B077 FROM 12 TO 14 WT CHG NEG		
T	ADDED STRINGER AND LOC. DIM. WGT. CHG. NEG.	4-14-42	
U	NOTE: "MAKE -6 --- FROM Y-2-A12T" WAS: "... --- 13" & NOTE: "MAKE --- Y-6-A6T" WAS "... --- 4." WT CHG NEG.	5-3-43	
V	IN -550 ASSY -25 WAS -23, -26 WAS -19. ADDED NOTE "MAKE --- 46A9T. DIM'S 1½ WAS 1⅜ & ¾ WAS ... WT CHG. NEG.	5-7-43	

E.O.34940 (R)
E.O. A3068 (T)
E.O. 618765 (U)
E.O. 844270 (V)



LIST OF DASH NOS WITH MATERIAL FROM WHICH THEY ARE MADE

FOLLOWING EXTRUSIONS SPEC 46A9 COND T
7/8 x 9/16 x .060 EXT BULB ANGLE DIE #K1559 -21
5/8 x 1/2 x .060 PLAIN ANGLE DIE #K9876 -18

MAKE -6, -7, -8, -9, -10, -11, -12, & -13 FROM Y-2-A12T (U)

1/2 x 1 13/16 x .040 ALUM ALLOY SHEET (P)
SPEC 47A10 COND A HEAT TREAT SR-53
-16, -17

1/2 x 1 x .051 BENT ANGLE
SPEC 47A10 COND A HEAT TREAT SR53
-19

AL ALLOY SHEET SPEC 47A10 COND T (V)
-5 -20 -25

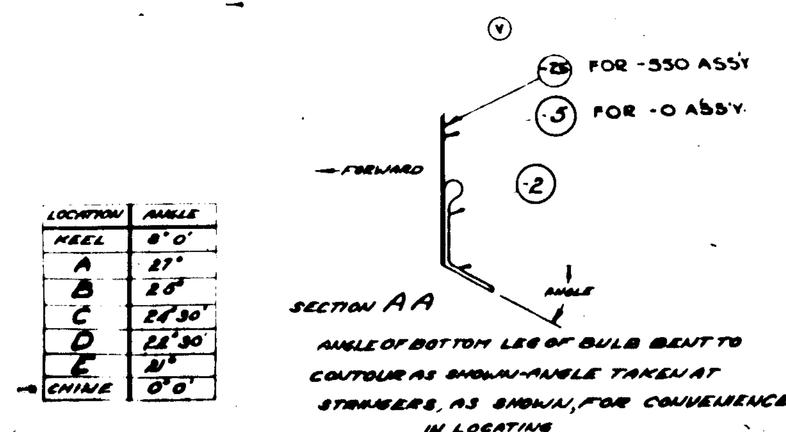
FOLLOWING EXTRUSIONS: SPEC 46A9 COND A HEAT TREAT SR-53 COND T
7/8 x 9/16 x .060 EXT BULB ANGLE DIE #K1559
-2 -14, -15 (Q)
MAKE -3 & -4 FROM Y-6-A6T (U)
MAKE -26 FROM K1288 AL. AL EXTRUSION 46A9T (V)

RIVET NOTES
ALL RIVETS TO BE AN442DS UNLESS OTHERWISE NOTED
ALL RIVETS NOT LOCATED BY DIMENSION ARE TO BE EQUALLY SPACED AS SHOWN

REF DRAWINGS
BULKHEAD ANGLES 28B036
HULL OFFSETS 28B003
STRINGER SPACING CHART 28B1007

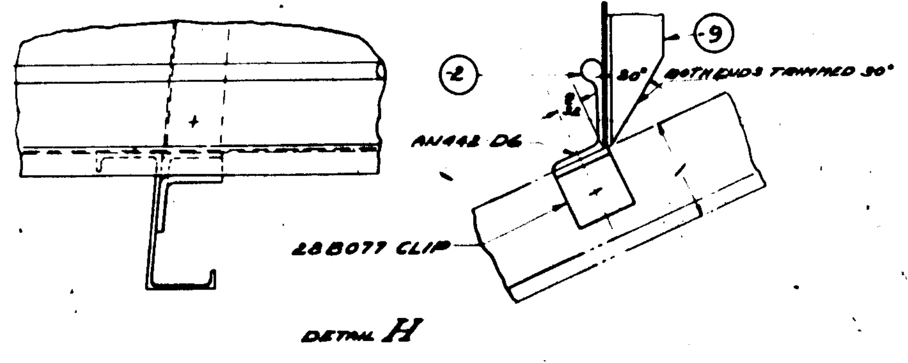
GP - GREEN PRIME

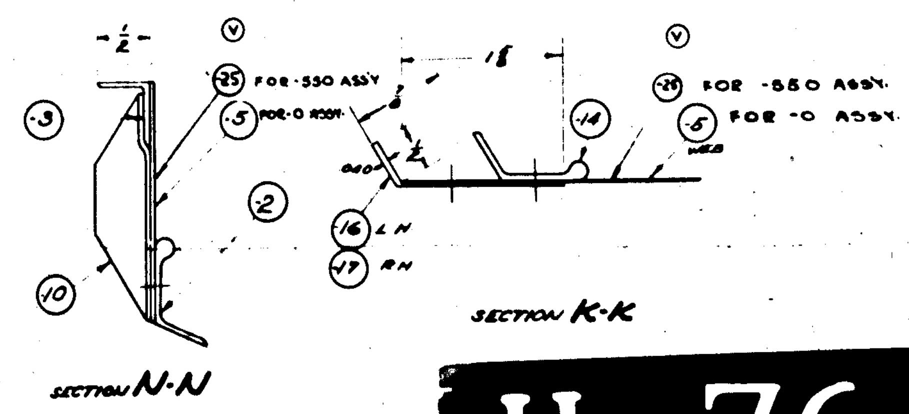
FINISH:
Z-P-GP ON XPBY-1 & PBY-1
Z-P-GP ON PBY-2 & FUTURE



LOCATION	ANGLE
KEEL	8°0'
A	27°
B	26°
C	24°30'
D	22°30'
E	21°
CHINE	0°0'

ANGLE OF BOTTOM LEG OF BULB BENT TO CONTOUR AS SHOWN - ANGLE TAKEN AT STRINGERS, AS SHOWN, FOR CONVENIENCE IN LOCATING





CONTR 70496

O.N.	MODEL	NEXT ASSY	REQ.
-550	OA-10	28B5500	1
-550	PBY-5A	28B5500	1
-550	28-5AMN	28B5300	1
-550	28-5AMC	28B5800	1
-550	28-5MN	28B1000	1
-550	28-5ME	28B1000	1
-550	28-5MA	28B1000	1
-550	28-5MC	28B1000	1
-550	PBY-5	28B1000	1
	PBY-4	28B1000	
	PBY-3	28B1000	
	PBY-2	28B1000	
	XPBY-1	28B001	
	PBY-1	28B1000	

REPLACES 28B033 ON-30-34
APPROVED ... 3-28-37 DATE
REPLACED BY
LIMIT ON DIMENSIONS UNLESS OTHERWISE SPECIFIED ± 1/64
[redacted]

SCALE 6" = 1'-0"
NAVY NOTED MATERIAL | NOTED SPEC. | NOTED HEAT TREAT | NOTED FINISH

CONSOLIDATED AIRCRAFT CORP. BUFFALO, N.Y.

NAME: BELT FRAME - HULL STATION 0.33

J 28B1033

H 76